



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4776-5

Job Sheet 184971



Part No: D4776-5

Job Qty: 60 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/19/18

Job Tracking No:

Due Date: 11/12/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D SHEET 3 IPP REV:A NEW ISSUE 13-08-30 JLM VERIFIED BY:DD IPP REV:B 13.09.26 AS
PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea	11/12/18	11/12/18	0.00	0.00	Start Up Machining-3		
100	Doosan	60 pcs	11/12/18	11/12/18	0.05	3.35	Doosan		
120	QC	60 pcs	11/12/18	11/12/18	0.00	0.00	QC8		
130	HandFinish	60 pcs	11/12/18	11/12/18	0.00	0.29	HandFinish1		
140	QC	60 pcs	11/12/18	11/12/18	0.00	0.00	QC7-4		
150	Packaging	60 pcs	11/12/18	11/12/18	0.00	0.00	Packaging3-2		
160	QC21-SA	60 Ea	11/12/18	11/12/18	0.00	0.00	QC21		

Part Op Descriptions: 100 - 1-Turn as per Folio and Dwg

OCT 30 2018 9-50 21 9-50 30AS 6 9-89 6

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.500	6061-T6 Round Bar .500"	1.2000 ft (.02 ea)	90-Start up Operation	FM138 1090

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.500	1	34	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.130Inches ± 0.030	0.160 0.100		
2	Spacer	0.250Inches ± 0.030	0.280 0.220		
3	Spacer	0.625Inches ± 0.010	0.635 0.615	Diameter	
4	Spacer	0.438Inches ± 0.010	0.448 0.428	Diameter	
5	Spacer	0.203Inches + 0.005 - 0.001	0.208 0.202	Diameter	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging supplier ☐ Engineering Quality ☐ Other ☐			
Date : _____		Step # : _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation							
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			

Root Cause		FAULT C					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Crack ☐	Weld ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Weld ☐	Wrong Stock Pulled ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Out of Sequence ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Inspection Incomplete/Unqualified ☐	Off-set ☐	Part Lost/Missing ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Contamination ☐	Mislabeled ☐	Part Moved ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Countersink ☐	Fit/Function ☐	Drawing ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Cut Too Short ☐	Misaligned/off center ☐	Finish ☐	Part Moved ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Instructions Incomplete/Unclear ☐		Misread ☐	Part Moved ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Drill Holes ☐		Turning Sequence ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐					
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER : _____					

1270 Aberdeen Street
Haverhill, MA 01830
CANADA
TEL: 1 800 632-8200
Email: sales@dartaero.com
www.dartaero.com



Container No: S119995



Part: D4776-5

Job No: 184971

Revision:

Inspector:

Exp Date:

Instructions:

Various STC's

Date: 10/21/18